






**Work Order ID 71366**

Wednesday, June 29, 2011 3:02:47 PM




Page 1


Item ID: D2989-043 Accept  Setup Start   
Revision ID:  
Item Name: Basket Lid Assembly Stop   
Start Date: 6/29/2011 Start Qty: 1.00  Cust Item ID:  
Required Date: 7/7/2011 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan:  Date: 11-06-29 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs in DT9446 jig, weld as per dwg D2989 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig 3- to locate hinges and shims use D2989-041, weld as per dwg D2989 A/R ER316 S.S. Rod Batch: <u>M115778</u>								

 11.07.14

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									

 11.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71366**

Page 2

Wednesday, June 29, 2011 3:02:47 PM

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 6/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

*S. Wozniak*

Memo

0.00

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

*1 BR 11-7-14*

W/O:		WORK ORDER CHANGES					
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Required Date:	7/7/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	<div> <div>1117745</div> <div>1ST COAT</div> <div>START TIME: 3:25</div> <div>OVEN TEMPERATURE: 400°</div> <div>FINISH TIME: 3:55</div> <div>***** 2nd coat if necessary*****</div> <div>2ND COAT:</div> <div>START TIME: _____</div> <div>OVEN TEMPERATURE: _____</div> <div>FINISH TIME: _____</div> </div>								
140 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

1 BL 11-7-14

1 & 11-10-15

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 6/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Packaging

Identify as per dwg &amp; Stock Location:

GA

0.00

Memo

w/o

0.00

71363

ES 4/07/15 ①

160



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/07/15

Quality Control

MF 1107-15

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# Picklist Print

Wednesday, June 29, 2011 3:02:53 PM

Page 1

Work Order ID: 71366

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly




Start Date: 6/29/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	8.0000	1	1		11.07.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				69261		5							
				WA006		3							
				67465		3							
D2989-3  Rib		Manufactured	No			100	Each	2.0000	1	1		11.07.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				69113		2							
D2989-4  Rib		Manufactured	No			100	Each	2.0000	1	1		11.07.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				70132		2							

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 71366

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 6/29/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-5 Manufactured No

100 Each

2.0000

2

2



Rib

B 71222

(2)



11.07.12

Location

Loc Qty

Loc Code

WA005

2

70133

2

D3182-1 Manufactured No

100 Each

12.0000

2

2



Hinge

Location

Loc Qty

Loc Code

WA

6

71223

6

WA005

6

69127

2

70135

4

D3442-3 Manufactured No

100 Each

17.0000

2

2



Shim

Location

Loc Qty

Loc Code

WA

2

67426

2

WA005

15

70671

15

D3827-041 Manufactured No

100 Each

1.0000

1

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

1

69114

1

B70675

(1)



11.07.12

Wednesday, June 29, 2011 3:02:54 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Wednesday, June 29, 2011 3:02:54 PM

Page 3

Work Order ID: 71366

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 6/29/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3832-5 Manufactured No

100 Each

3.0000

1

1



Mesh (Lid)



11.07.13

Location

Loc Qty

Loc Code

WA

3

69174

3

D3833-5 Manufactured No

100 Each

56.0000

2

2



Mesh (Lid End)



11.07.13

Location

Loc Qty

Loc Code

WA

56

67461

56

D3838-041 Manufactured No

100 Each

0.0000

1

1



Rib Assembly (Basket Lid, LH)

B70136

0



11.07.12

D3838-042 Manufactured No

100 Each

0.0000

1

1



Rib Assembly (Basket Lid, RH)

B70137

0



11.07.12

Wednesday, June 29, 2011 3:02:54 PM

Shop Packet Print

Page 3

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71364

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/8

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG); REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D2989	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

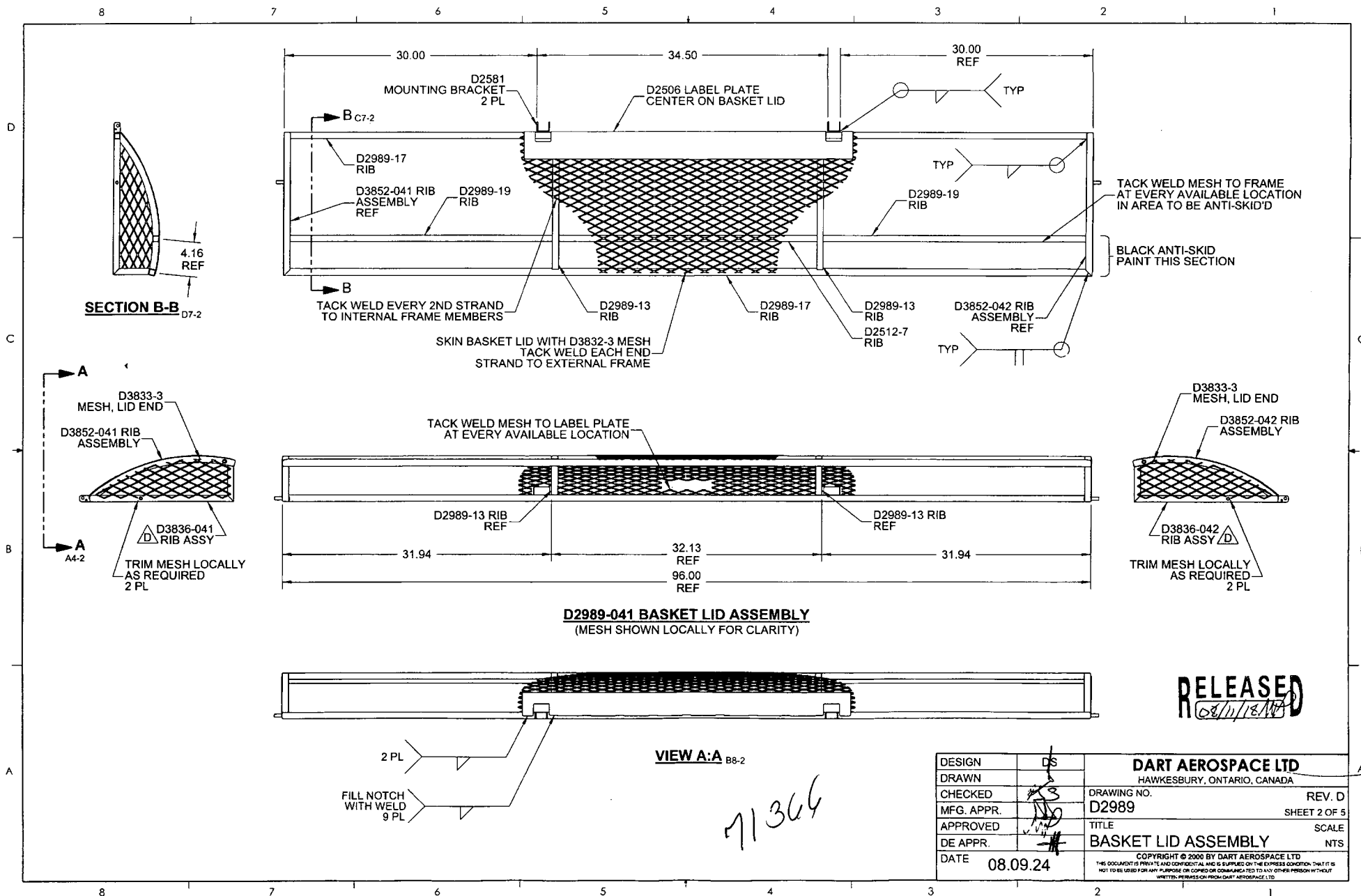
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

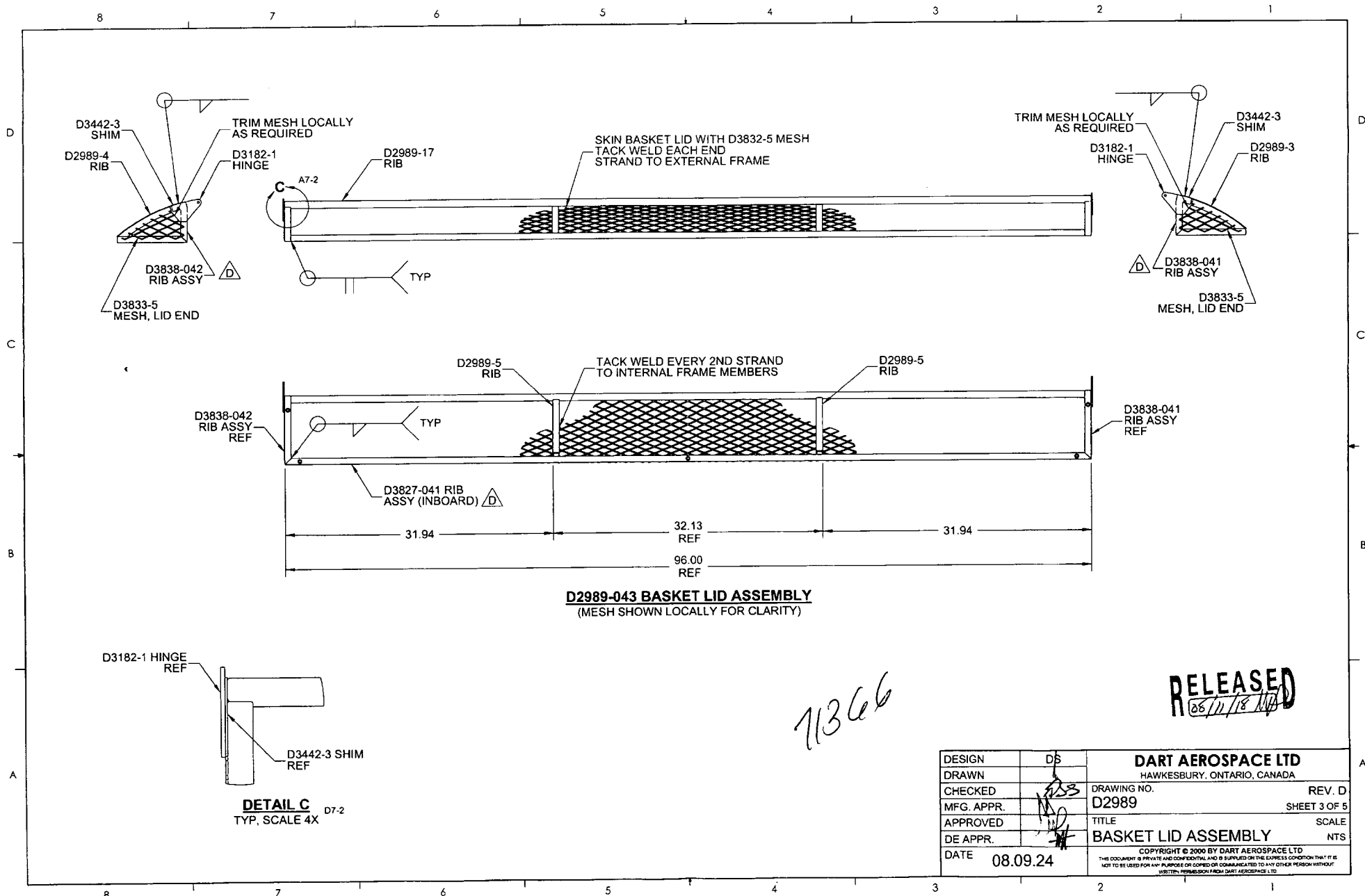
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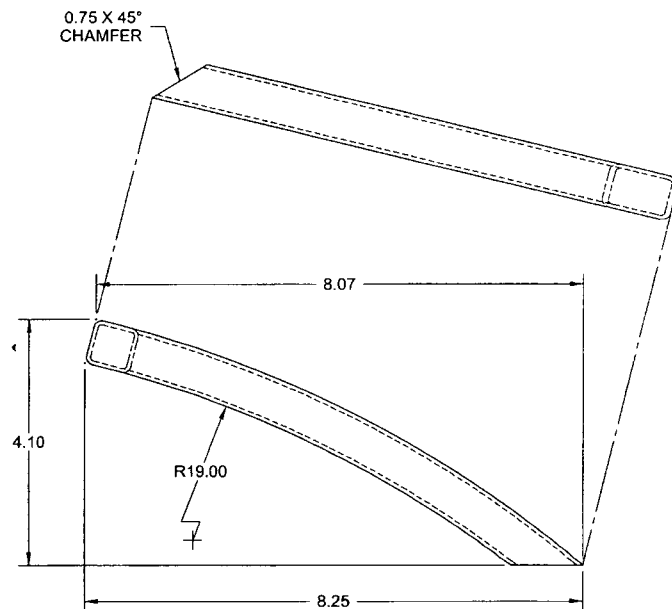
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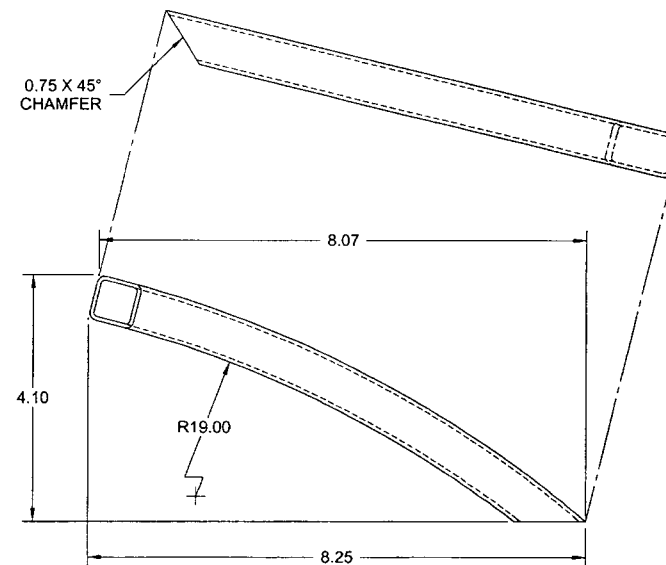
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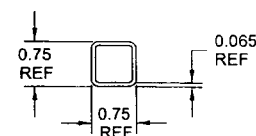
**NOTE:** Date & initial all entries



**D2989-3 RIB**



**D2989-4 RIB**



**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON OR FIRM WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>	

**RELEASED**  
08/11/18

71366

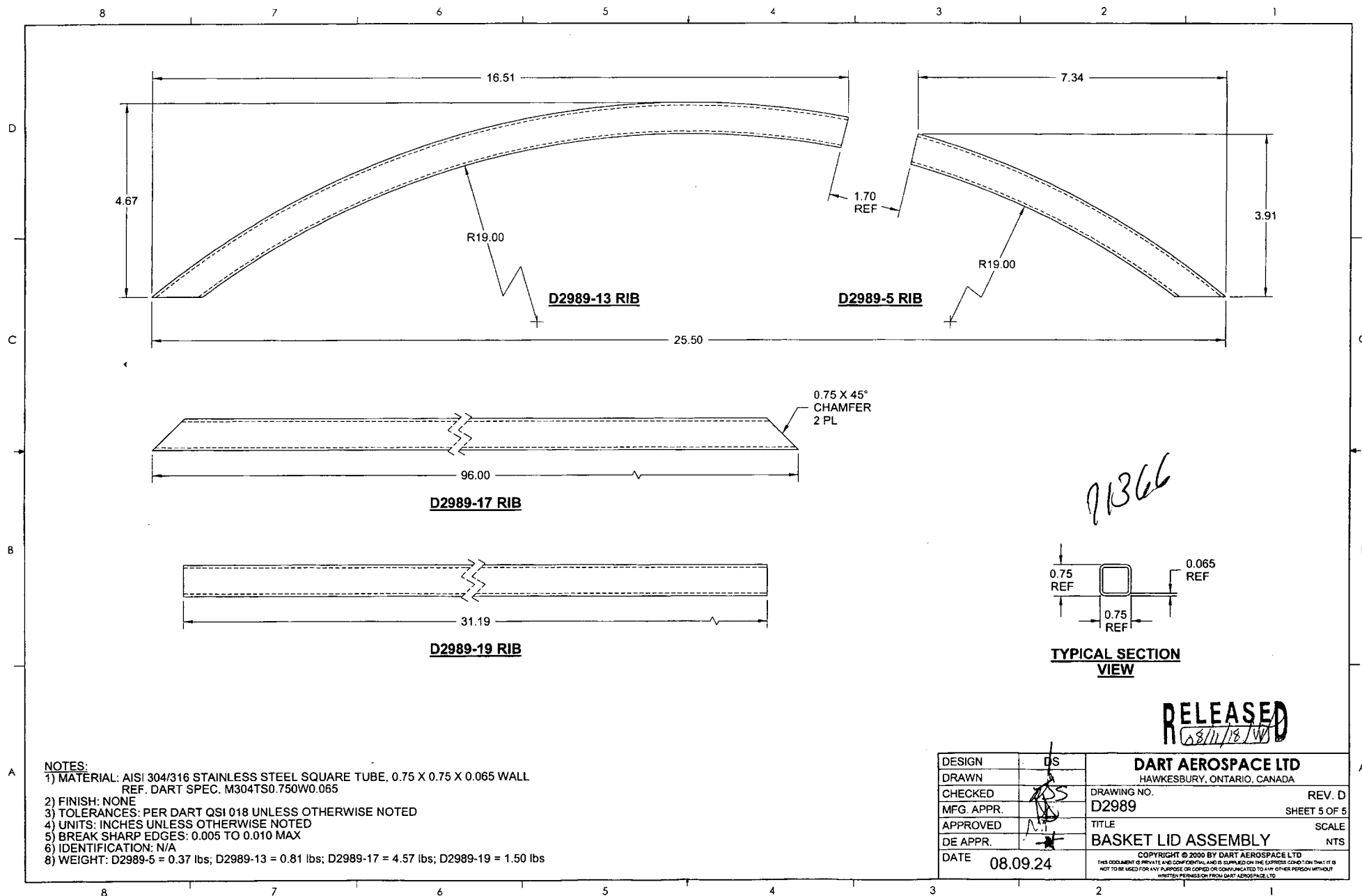
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DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	DS	D2989	SHEET 5 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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